

Work Order ID 50130 -1



SP18

July 8, 2009 12:48:45 PM

Item ID: D2807-041

Accept



Setup Start



Revision ID: E

Stop



Item Name: Door prop

Start Date: 7/08/09 Start Qty: 40.00



Cust Item ID:

Required Date: 7/10/09 Req'd Qty: 40.00



Customer:

Reference:

Approvals:

Process Plan: CL09/07/08

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2807

Rev E

100

0.00



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 10032 ☐ Order as per Dwg D2807 ☐ Possible  
supplier: Lift Support Technologies, Saskatoon, Canada ☐ P/N 6/15-164/50-115N  
☐  
Material release note is required

CL 09/07/08 40

110

0.00



Receive & Inspect for Damage & Mat'l Certs

Packaging

Memo

0.00

Packaging

Ensure Material Release Note is attached

CL 09/08/11 4

120

0.00



QC6- Inspect dimensions to drawing

QC

Memo

0.00

Quality Control

=> Sent 08/14  
@ 35 lbs force

CL 0

# Work Order ID 50130

July 8, 2009 12:48:45 PM



Page 2

Item ID: D2807-041

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Setup Start



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Item Name: Door prop

Stop



Start Date: 7/08/09 Start Qty: 40.00



Cust Item ID:

Required Date: 7/10/09 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	1-install D3671-1 as per dwg D2807								
140 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
150 	Identify as per dwg & Stock Location: <u>48</u>	0.00							
Packaging	Memo	0.00							
Packaging									

*CP 09/08/18* (Y)

*=> Sort out 18*

(KE) f

*9/8/18* (42) SP

# Work Order ID 50130



Page 3

July 8, 2009 12:48:45 PM

Item ID: D2807-041

Accept



Setup Start



Revision ID: E

Stop



Item Name: Door,prop

Start Date: 7/08/09 Start Qty: 40.00



Cust Item ID:

Required Date: 7/10/09 Req'd Qty: 40.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set-Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

07/08/25 HJ 4 BL 29-08-24

# Picklist Print

July 8, 2009 12:48:45 PM

Work Order ID: 50130

Parent Item: D2807-041RevE

Parent Item Name: Door prop

Comments:

Start Date: 7/08/09

Required Date: 7/10/09

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D3671-1RevA

Manufactured

No

110

Each

29.0000

40.0000



Placard

*EP 08/08/18*  
*B50174*

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

29

44911

29

6/15-164/50-115N

Purchased

No

130

Each

0.0000

40.0000



Gas Spring

*CL 09/08/11* *(4)*

# SPECIFICATION CONTROL DRAWING

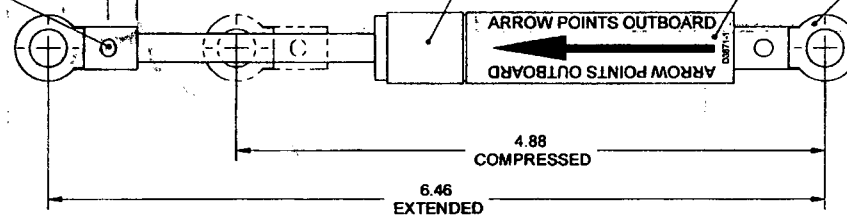
(ALTERNATE ONLY)  
CRIMP 0.015-0.025 DEEP  
WITH Ø0.375 TOOL AT  
2000psi (REF), TYP TWO  
SIDES PER LUG

0.24 TO CRIMP  
(TYP)

D2807-5  
OR  
(ALTERNATE ONLY) D2807-1

AFFIX D3671-1 PLACARD  
ENSURE PLACARD DOES NOT  
CONCEAL ANY TEXT OR MARKINGS  
ON THE GAS SPRING

(ALTERNATE ONLY) D2807-3  
BOTH ENDS



**D2807-041 GAS SPRING**

## D2807-041 GAS SPRING ASSEMBLY PARTS LIST

QTY -041	PART NUMBER	DESCRIPTION
X	D2807-041	GAS SPRING ASSEMBLY
1	D2807-5	GAS SPRING
1	D3671-1	PLACARD

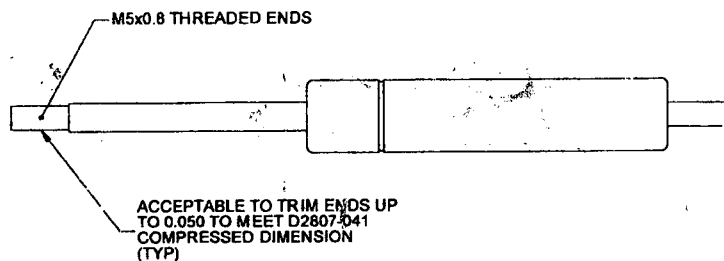
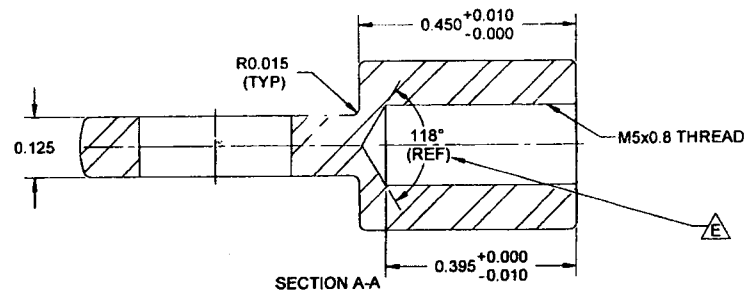
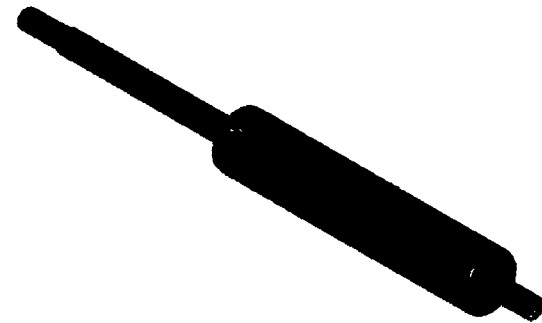
### NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.169 LBS
- 8) ALTERNATE PART: D2807-5 CAN BE MADE FROM ASSEMBLING D2807-1 (1) AND D2807-3 (2)  
(WEIGHT: 0.176 LBS)

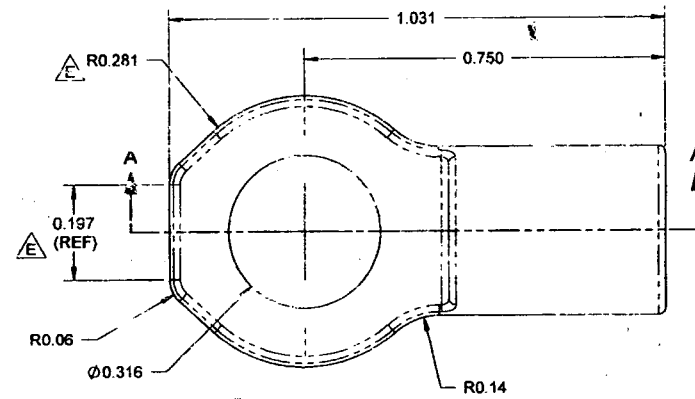
E	ADD D2807-5 GAS SPRING; D2807-1/3 ASSEMBLY IS AN ALTERNATE TO D2807-5 GAS SPRING; UPDATE DIMENSIONS ON D2807-3	PH	07.12.28
D	ADDED D3671-1 PLACARD ADDED -041 ASSEMBLY UPDATED DWG	DC	07.09.27
C	CHANGE SPRING TO SS, ADD -3 LUG	CP	05.05.25
B	ADD FINISH	CP	05.03.16
A	NEW ISSUE	DS	00.11.03
REV.	DESCRIPTION	BY	DATE

DESIGN	4	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	#		
CHECKED	JE	DRAWING NO.	REV. E
MFG. APPR.	W	D2807	SHEET 1 OF 3
APPROVED	W	TITLE	SCALE
DE APPR.	W	GAS SPRING	NTS
DATE	07.12.28	<small>COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

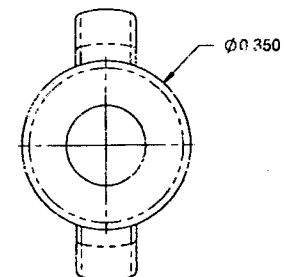
W10: 50130  
C/L 09/10 8/108



**D2807-1 GAS SPRING**  
SCALE 1:1



**D2807-3 LUG**



**D2807-1 GAS SPRING NOTES:**

- 1) POSSIBLE SUPPLIER: ARVINMERITOR MOTION CONTROL SYSTEMS, LEICESTER, UK  
(P/N SXF6S6050080S6L-115N)  
(REF: 80MM LONG CYLINDER, 50MM STROKE, 115N LOAD)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.144 LBS
- 8) SPECIFICATION: SS GAS SPRING  
ACCEPTABLE LOAD RANGE IS 25 LB (115 N) MIN TO 45 LB (200 N) MAX  
M5x0.8 THREADS

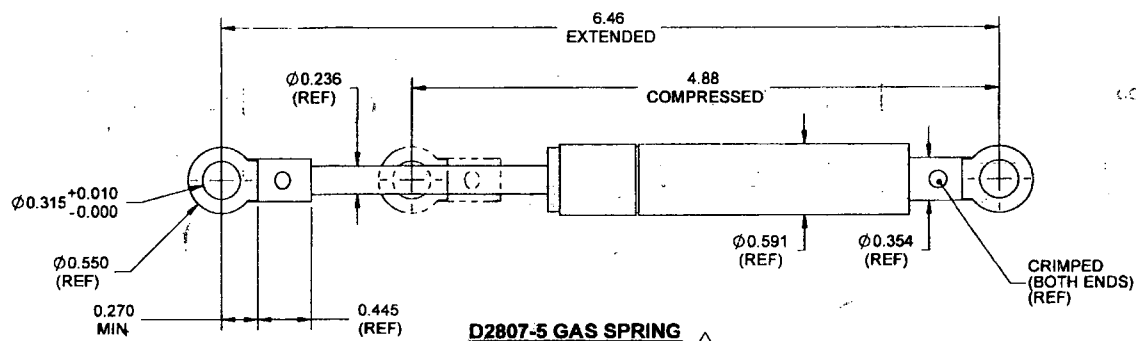
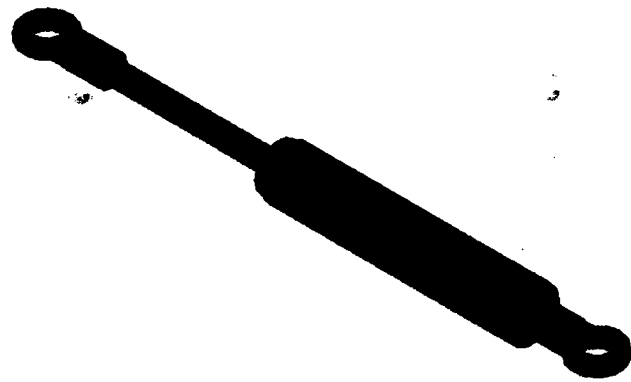
**D2807-3 LUG NOTES:**

- 1) MATERIAL: AISI 303 ROUND BAR (REF. DART SPEC. M303R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.015
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.016 LBS

DESIGN	#	<b>DART AEROSPACE LTD</b>	
DRAWN	#	HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	DRAWING NO. D2807	REV. E
MFG. APPR.	#	SHEET 2 OF 3	
APPROVED	#	TITLE	SCALE
DE APPR.	#	GAS SPRING	4:1
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50130

RELEASED



**D2807-5 GAS SPRING**

50130

**D2807-5 GAS SPRING NOTES:**

- 1) POSSIBLE SUPPLIER: LIFT SUPPORT TECHNOLOGIES, SASKATOON, CANADA (P/N 6/15-164/50-115N)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.169 LBS
- 8) SPECIFICATION: SS GAS SPRING WITH END FITTINGS, ACCEPTABLE LOAD RANGE 25 LB (115 N) MIN TO 45 LB (200 N) MAX

DESIGN	PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH		
CHECKED	KE	DRAWING NO. D2807	REV. E
MFG. APPR	KE	SHEET 3 OF 3	
APPROVED	KE	TITLE	SCALE
DE APPR	KE	GAS SPRING	4:1
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LS Technologies Canada Inc.

303 - 103 Street  
Saskatoon, SK Canada  
S7N 1Y9

# Packing Slip

P.O. No.	Date	Packing Slip #
10032	8/10/2009	5295

Name / Address
Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7 Canada

Ship To
Main Finished Goods Location Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7 Canada

Rep	Ship Date	Ship Via
Nolan	8/10/2009	Purolator

Qty	Description
4	D2807 - Stainless Gas Spring C 207/08/11 Shipping via PUROLATOR Collect - Tracking # 329119156654 Total GST Business Number: 875007718 S 02/04/14





303 – 103<sup>rd</sup> Street, Saskatoon, Saskatchewan, Canada S7N 1Y9  
Ph: (306) 683-5000 Fax: (306) 683-6403  
E-mail: [lstech@lstechtechnologies.ca](mailto:lstech@lstechtechnologies.ca) [www.liftsupporttechnologies.com](http://www.liftsupporttechnologies.com)

## Certificate of Compliance

This is to certify that the parts listed below meets specifications as required by your order.

**4 Units D2807 Stainless Gas Spring**

**Country of Manufacture: Canada**

**Date of Manufacture : July 2009**

**This product is ROHS compliant.**

**We certify no mercury was used in the manufacture of this order.**

Purchase Order # 10032

Invoice # 5295

*S. Selby*

L S Technologies Inc Canada

A handwritten signature in black ink, appearing to be "Nolan Fehr", written over a horizontal line.

Nolan Fehr  
Manager